

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	36426	<i>3</i>	Part Number	D35371
Estimate Number	12712		Drawing Number	D3537 REV C
P.O. Number			Project Number	N/A
This Issue	12/18/2007	S.O. No. :	Drawing Revision	C
Prsht Rev.	NC		Material	
First Issue	/ /	Type : SMALL /MED FAB	Due Date	1/25/2008
Previous Run	36370		Qty:	100
Written By			Um:	Each
Checked & Approved By		<i>12/18/07</i>		
Comment	Est Rev:A	New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: <i>106652</i> <i>106653</i> <i>1B</i> <i>08-1-2</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <i>C</i> <i>1B</i> <i>08-1-2</i> Prog Rev: <i>C</i> <i>HB</i> <i>08-1-2</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>1B</i> <i>08-1-2</i>		
4.0	QCB	SECOND CHECK
Comment: SECOND CHECK <i>OSPO19</i> <i>08/01/08</i> <i>103</i> <i>counter</i>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1		

Date: Tuesday, 12/10/2001 10:31:21 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36426

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M106115

1-Weld as per Dwg D3537 using Jig DT 8210

H107051

08-05-10 SP

2-Remove any weld that penetrated through Wearpadif necessary

08-04-10 CIP

7.0 QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M105442

B36426

D35371

01/05/2008

S.172 10.08

#1 519.9 F

#2 304.70 F

#3 304.70 F

#4 304.70 F

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 08-05-01

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/05/01

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P-20

M 08/05/01

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01

Job Completion:



W 08/05/01

DART AEROSPACE LTD	Work Order:	36426
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

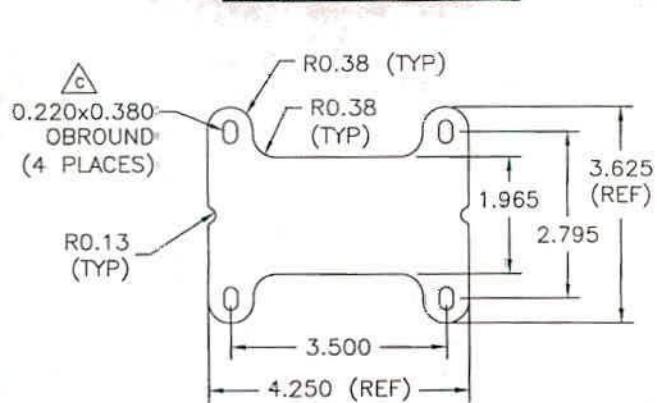
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

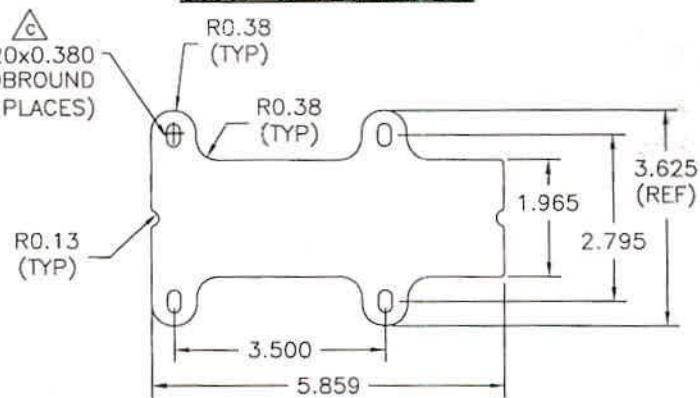
Measured by: <u>HB</u>	Audited by: <u>C</u>	Prototype Approval: N/A
Date: 08-1-2	Date: 08/01/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	✓ <i>[Signature]</i>

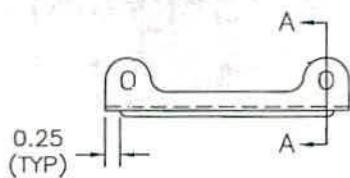
D3537-1F FLAT PATTERN



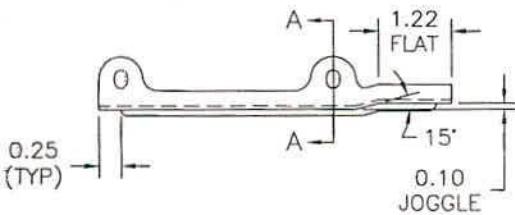
D3537-3F FLAT PATTERN



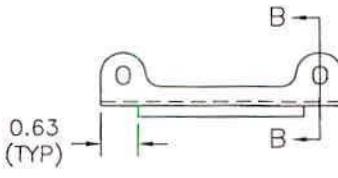
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



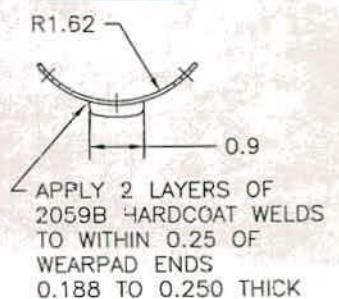
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD FER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

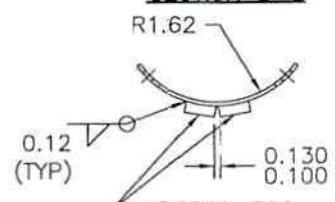
WORK ORDER
2014-2
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SECTION A-A

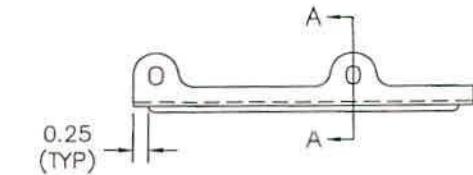


SECTION B-B



RELEASED
07.05.08 A4
per ECR 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH DART AEROSPACE USA, INC. PORT HUDDLE, VA
CHECKED	4	APPROVED 4 DRAWING NO. D3537 REV. C
DATE	07.04.13	TITLE WEARPAD SCALE 1:2

